

Work Order ID 82252

82252

Page 1

March-27-12 2:41:22 PM

Item ID: D3536-39 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket
 Start Date: 27/03/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 10/04/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/27 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3536	Rev A

100 FLOW WATER JET 0.00
100
 Waterjet
 FLOW CNC Waterjet
 Memo
 1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary
 B Jm 120403 (12)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC
 Quality Control
 Memo
 0.00
 B/Jm 120403 (12)

120 QC8- Inspect parts - second check 0.00
120
 QC
 Quality Control
 Memo
 0.00
 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>FP</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

(12a) SP 12-04-05

12/4/5

012-04-5

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March-27-12 2:41:26 PM

Page 1

Work Order ID: 82252

82252

Parent Item: D3536-39

D3536-39

Parent Item Name: Gasket

Start Date: 27/03/2012

Required Date: 10/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	702.5020	0.7534	10.04533			

MNEO60S 063

NEOPRENE SHEET 0.063

**

Location

Loc Qty

Loc Code

MAT052

702.502

119777

3.752

120948

698.75

120948

B / Jm

120403

12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82252
Description: Gasket		Part Number:	D3536-39
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/-0.030	35.71	✓		MT	HB-01
32.78	+/-0.030	32.78	✓		MT	HB-01
29.28	+/-0.030	29.28	✓		MT	HB-01
25.78	+/-0.030	25.78	✓		MT	HB-01
23.25	+/-0.030	23.25	✓		MT	HB-01
19.75	+/-0.030	19.75	✓		MT	HB-01
17.75	+/-0.030	17.75	✓		MT	HB-01
14.25	+/-0.030	14.25	✓		MT	HB-01
9.50	+/-0.030	9.50	✓		MT	HB-01
4.75	+/-0.030	4.75	✓		Vern	HB-02
5.00	+/-0.030	5.00	✓		Vern	HB-02
9.00	+/-0.030	9.00	✓		Vern	HB-01
0.30	+/-0.030	0.30	✓		Vern	HB-02
0.30	+/-0.030	0.30	✓		Vern	HB-02
1.88	+/-0.030	1.88	✓		Vern	HB-02
Ø0.19	+0.005/-0.001	0.19	✓		Vern	HB-02
0.063	+/-0.010	0.063	✓		Vern	HB-02

Measured by: <i>P/Jm</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: <i>12/04/03</i>	Date: <i>12/04/03</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJJ/JLM	<i>[Signature]</i>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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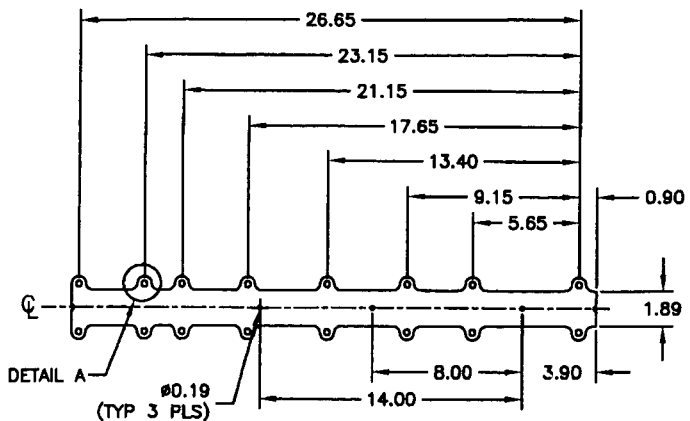
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DART

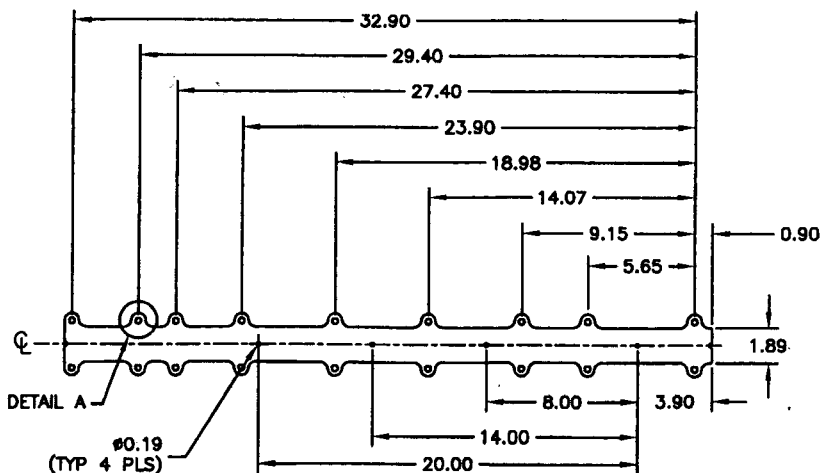
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09.02.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82252 MCLJ

12/03/27



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	CB	PORT HADLOCK, WA
CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 1 OF 6
A	06.10.25	NEW ISSUE
		SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

PORT HADLOCK, WA

DRAWN BY
CB
APPROVED

DRAWING NO.

CHECKED
PH

APPROVED

D3536

SHEET 2 OF 6

DATE _____

06.10.25

TIME	
GASKET	

1:10



- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

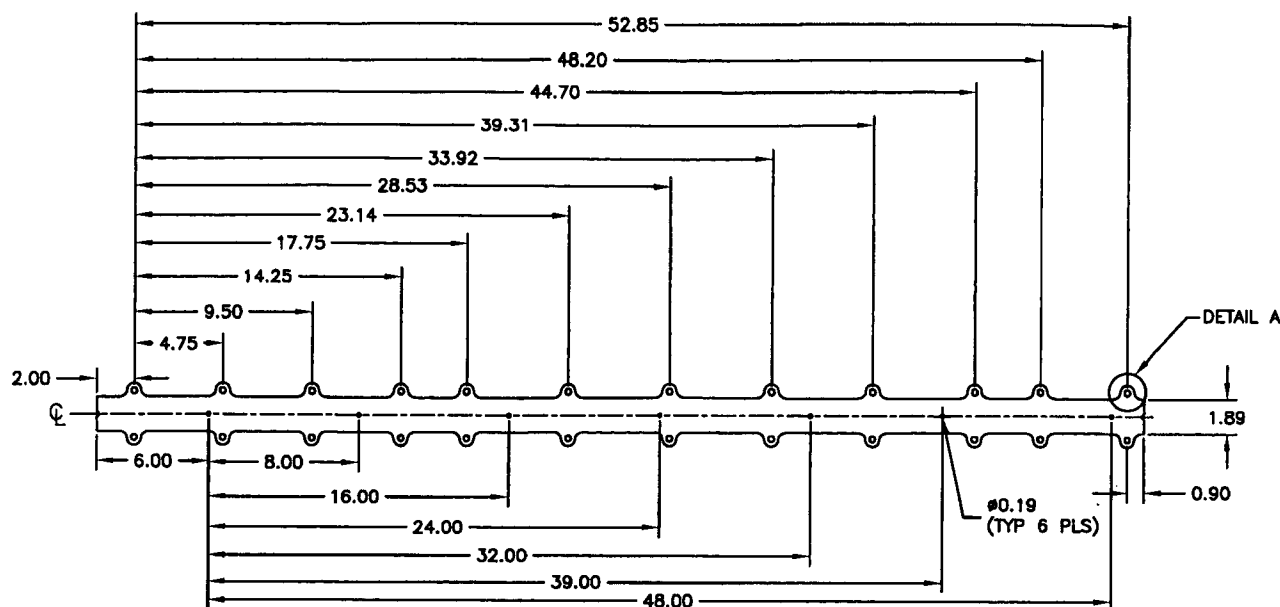
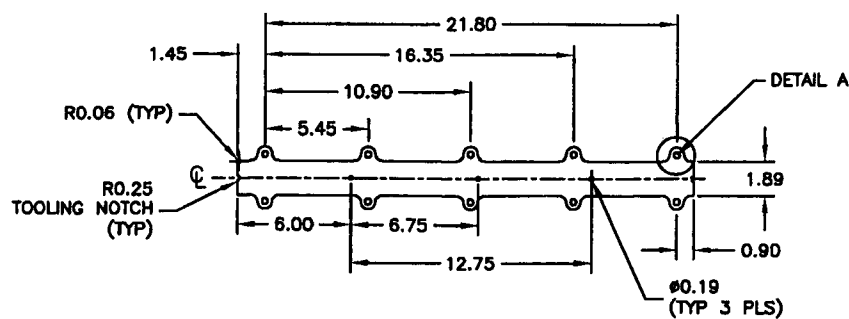
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

82252

DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.	REV. A
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	SHEET 3 OF 6
DATE	06.10.25	TITLE	GASKET	SCALE	1:10
		DRAWING NO.	D3536		

**D3536-23 GASKET****D3536-25 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

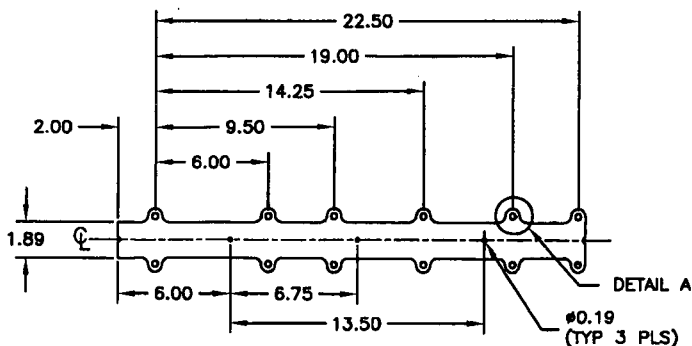
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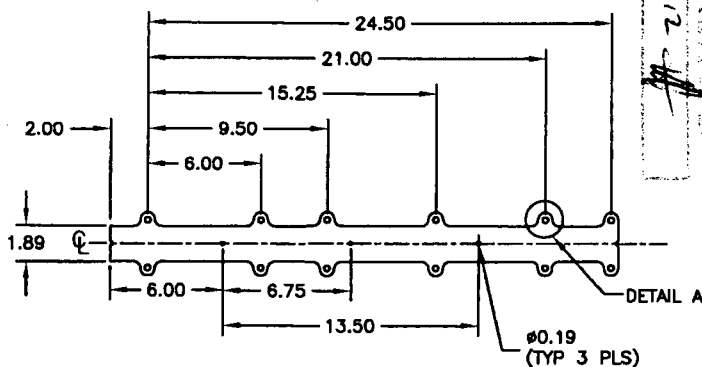
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 4 OF 6
				SCALE
				1:10

82252

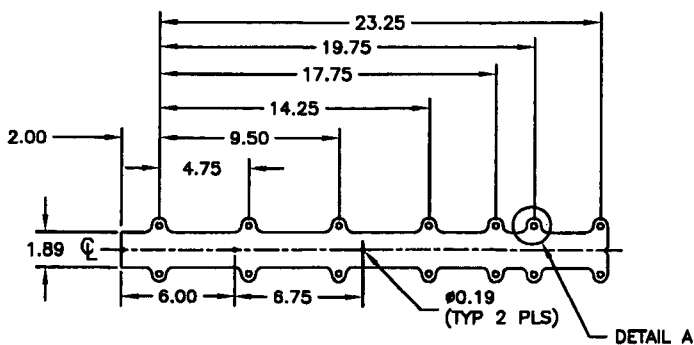
07.02.12



D3536-31 GASKET



D3536-33 GASKET



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

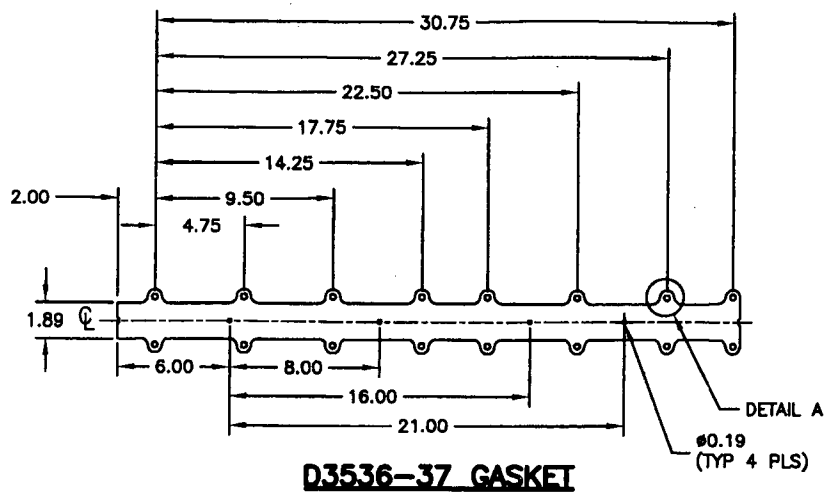
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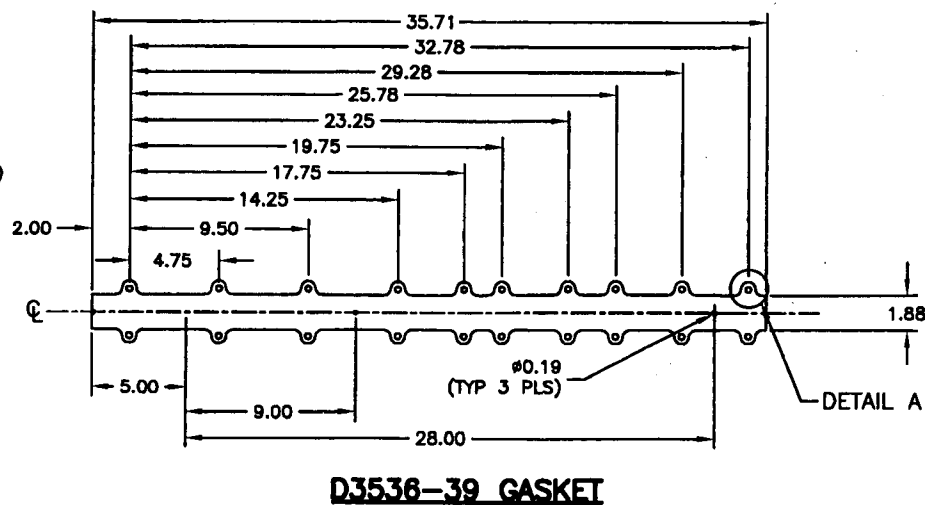
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DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 5 OF 6
				SCALE 1:10

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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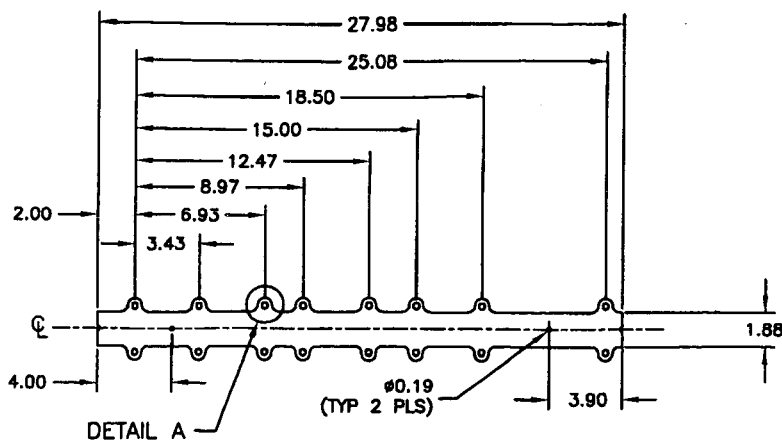
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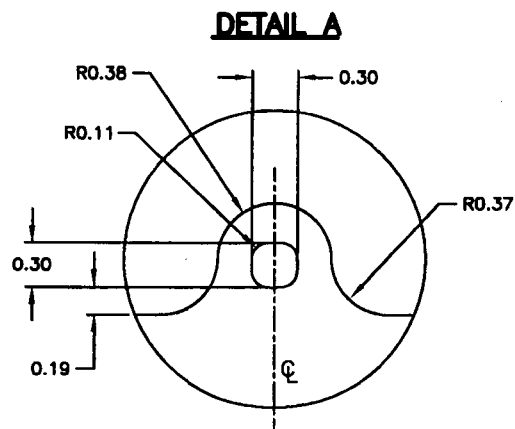
82252

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 6 OF 6	SCALE 1:10

**D3536-41 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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